

Date: Tuesday, 11/21/2006 1:36:03 PM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : PLUG
<b>Job Number</b> : 29621	
<b>Estimate Number</b> : 10178	
<b>P.O. Number</b> : <i>N/A</i>	<b>Part Number</b> : D25941
<b>This Issue</b> : 11/21/2006 <b>S.O. No.</b> : <i>N/A</i>	<b>Drawing Number</b> : D2594 REV B1
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : <i>N/A</i> <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : B1
<b>Previous Run</b> : 29490	<b>Material</b> : <i>N/A</i>
<b>Written By</b> : <i>[Signature]</i>	<b>Due Date</b> : 12/5/2006
<b>Checked &amp; Approved By</b> : <i>[Signature]</i> 06/11/21	<b>Qty</b> : <i>360</i> <b>Um</b> : Each
<b>Comment</b> : Est D 02.06.22 Make in Cobra KJ	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M6061T6R0625	6061-T6 Round Bar .625"
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**Comment:** Qty.: 0.0547 f(s)/Unit Total : 27.3525 f(s)  
 Material: 5052-H32 (QQ-A-225/7) or 6061-T6 (QQ-A-225/8)  
 1100-0 (QQ-A-225/1) Ø0.625" Rod  
 (M5052H32R0.625) or (M6061T6R0.625) Batch *4102286*

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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**Comment:** HARDINGE CNC LATHE SMALL  
 1-Make as per Dwg D2594-1 and Folio FA262.  
 2-Break all sharp edges 0.010 max.

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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**Comment:** HAND FINISHING RESOURCE #1  
 Acid etch and alodine as per QSI 005 4.1

*A.M* 06/11/29 *360*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: LD Date: 26/12/06  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/21/2006 1:36:03 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 29621

Part Number: D25941

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M102391



360

Comment: POWDER COATING

Powder Coat Gloss White (Ref: 4.3.5.1) per Dart QSI 005 4.3 (only larger dia. section necessary)

Ham 06/12/04

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



360

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 06/12/05

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PP

a.m 06/12/05

360

9.0

QC21

FINAL INSPECTION/W/O RELEASE



360

Comment: FINAL INSPECTION/W/O RELEASE

24/12/06

Job Completion



C Loc 11/2/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

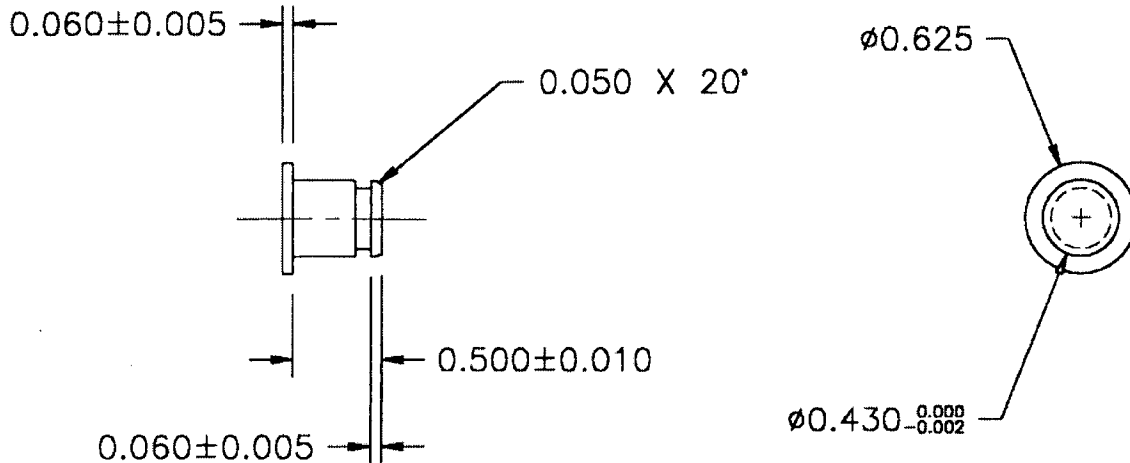




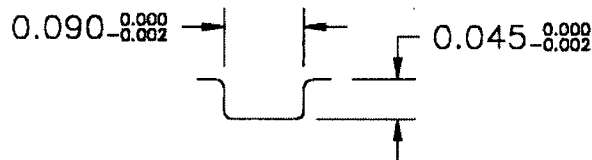
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BW</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2594	REV. B SHEET 1 OF 1
DATE 96:09:16		TITLE PLUG	SCALE 1:1
B	97:03:15	ADD GROOVE AND O-RING	
B1	<del>RF</del> 02.08.26	ADD POWDER COAT, QSE 018, & QQ-A SPECS.	

D2594-1 PLUG:

RELEASED  
97/03/27 DS



GROOVE DETAIL (SCALE 5:1)



TOOLERANCES ARE PER DART QSE 018 UNLESS OTHERWISE NOTED.

BREAK ALL SHARP CORNERS 0.010 MAX

MATERIAL: 5052-H32 OR 6061-T6 OR 1100-0

FINISH: ACID ETCH, ALODINE

POWDER COAT WHITE (REF. 43.S.1) PER QSE 005 4.3

PER QQ-A-225 / 7 (5052)  
OR QQ-A-225 / 8 (6061)  
OR QQ-A-225 / 1 (1100)  
OR QQ-A-200 / 8 (6061)

D2594-3 O-RING: 5/16 ID, 7/16 OD, 1/16 WIDTH  
(PARKER 2-011)

SHOP COPY  
RETURN TO  
ENGINEERING

UNCONTROLLED COPY

D2594 PLUG ASSEMBLY INCLUDES:

(1) D2594-1 PLUG  
(1) D2594-3 O-RING

SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER

NO. 29621